

FAASA- 119 baskets ASAP

Dart Aerospace Ltd.

Date: Tuesday, 2/26/2008 8:01:02 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 37620
Estimate Number : 12498
P.O. Number :
This Issue : 2/26/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL /MED FAB
Previous Run : 31801
Written By :
Checked & Approved By :
Comment : Est Rev: A New Issue 06-06-09 JLM

Drawing Name : CLEVIS

Part Number : D351613

Drawing Number : D3516 UNDER REVIEW

Project Number : N/A

Drawing Revision : B

Material :

Due Date : 3/14/2008

Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S11GA 304/316 .125 Sheet



.4



Comment: Qty.: 0.0218 sf(s)/Unit Total : 0.2184 sf(s)
304/316 .125 Sheet 11GA
(M304S11GA)
Batch: 104934 1B8-2-27

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3516
Dwg Rev: B
Prog Rev: B 1B8-2-27

(13)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



1B8-2-27



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

03/02/08 P22 (13)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Form as per Dwg D3516

SN 08/02/08

(13)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 08/03/07
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:01:02 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 37620

Part Number: D351613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

08/03/06 (13)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 106

AS 08/03/07 (13)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(13)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/07

Job Completion



mi 2008/3/07

(13)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|----------------------|----------------------|---|------------------------|
| DESIGN <i>B</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>H</i> | DRAWING NO. D3516 | REV. B SHEET 1 OF 5 |
| DATE 06.07.25 | | TITLE BASKET BASE ASSEMBLY (A119) | SCALE NTS |
| A | 06.06.21 | NEW ISSUE | |
| B | 06.07.25 | ADD (4) D3516-13, (6) D3516-11 WAS (10), SEE TR-D119-756-1 REV. A | |

RELEASED

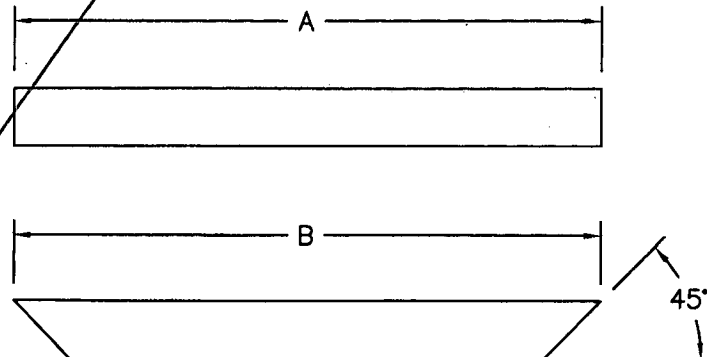
06.11.28 *H*

UNDER REVIEW

06.02.20 *H*ADDITION OF HOPS
& BUSHING PARTS**PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY**

| PART NO | QUANTITY | LENGTH A | LENGTH B | DESCRIPTION |
|----------|----------|-------------|-------------|---------------|
| D3516-1 | 2 | — | 102.00 | RIB |
| D3516-3 | 2 | — | 25.50 | RIB |
| D3516-5 | 8 | 26.75 | — | RIB |
| D3516-7 | 3 | 45.50 | — | RIB |
| D3516-9 | 4 | N/A | N/A | RIB |
| D3516-11 | 6 | N/A | N/A | CLEVIS |
| D3516-13 | 4 | N/A | N/A | CLEVIS |
| D2232-3 | 2 | N/A | N/A | HINGE PLATE |
| D2327-3 | 2 | N/A | N/A | BUSHING |
| D2581 | 2 | N/A | N/A | MOUNTING BRKT |
| D3442-1 | 2 | N/A | N/A | SHIM |

B

**NOTES:**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING (REF. DART SPEC. M304TS0.750W.065)
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

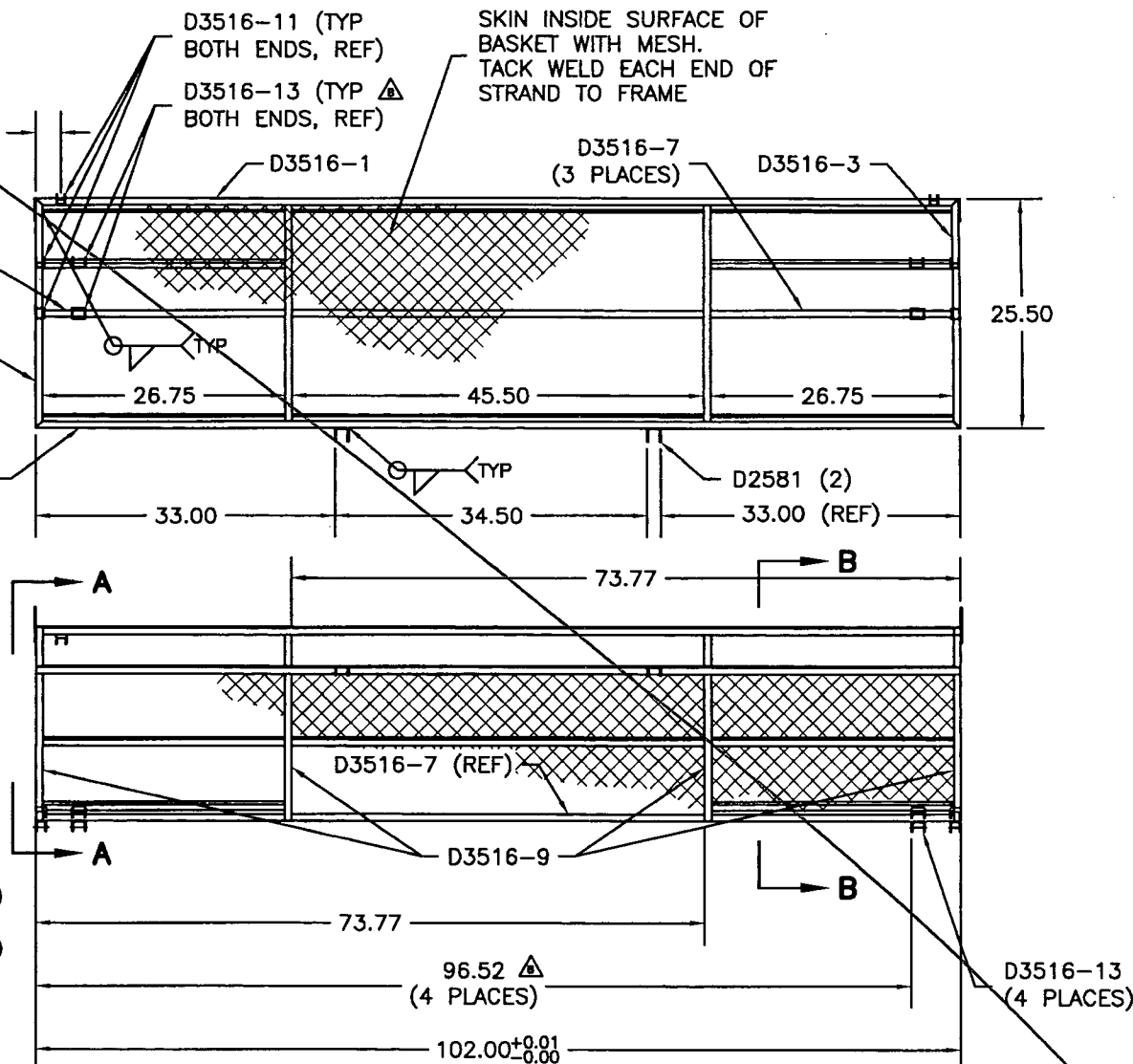
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| DATE 06.07.25 | DRAWING NO. D3516 | TITLE BASKET BASE ASSEMBLY (A119) | SHEET 2 OF 5 |
| | | | SCALE 1:20 |



D3516-041 BASKET BASE ASSEMBLY

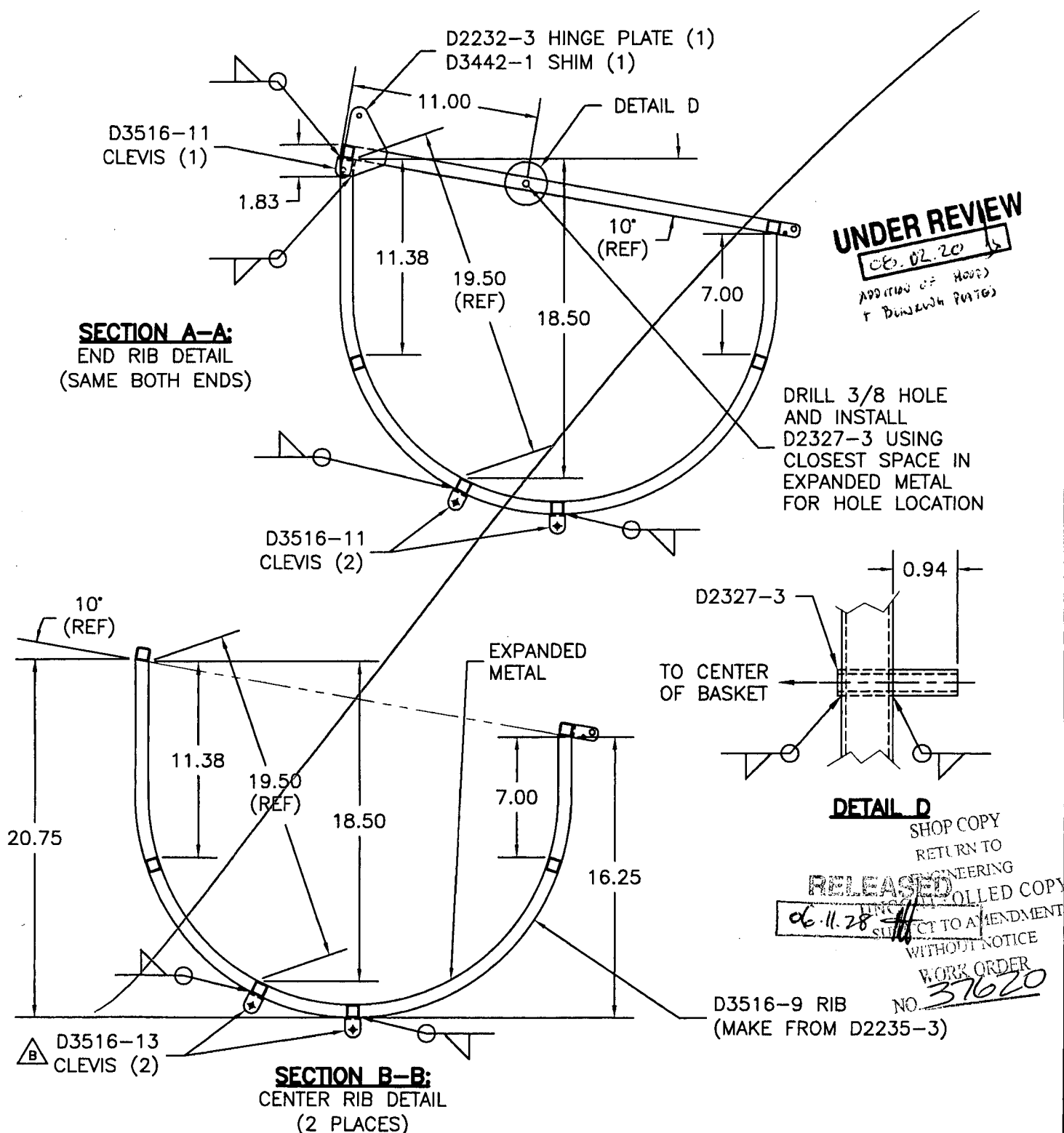
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06.11.28

UNDER REVIEW
06.07.20
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| DATE 06.07.25 | | TITLE BASKET BASE ASSEMBLY (A119) | SCALE 1:8 |

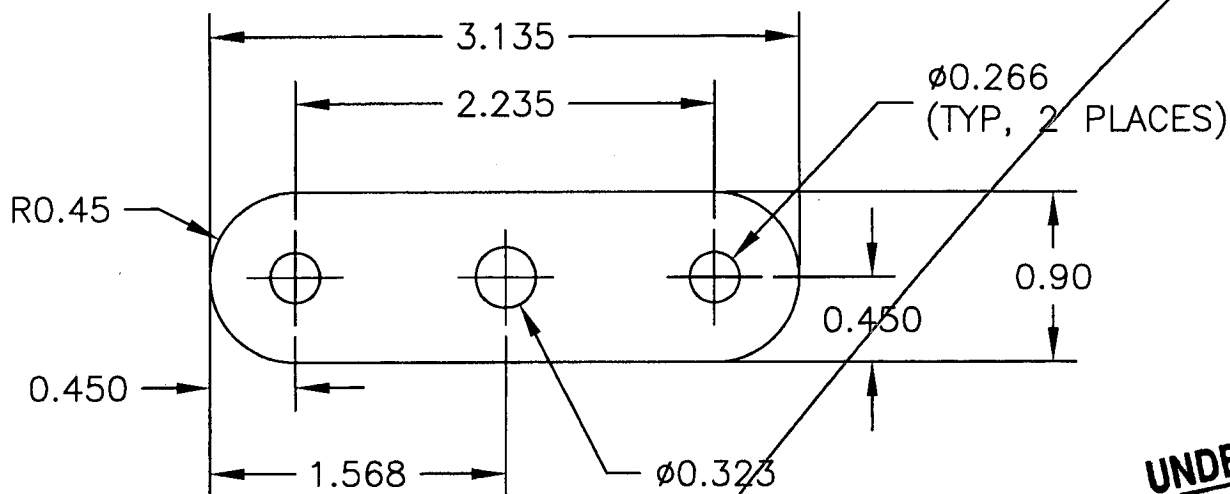


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| DATE 06.07.25 | | TITLE BASKET BASE ASSEMBLY (A118) | SCALE 1:1 |

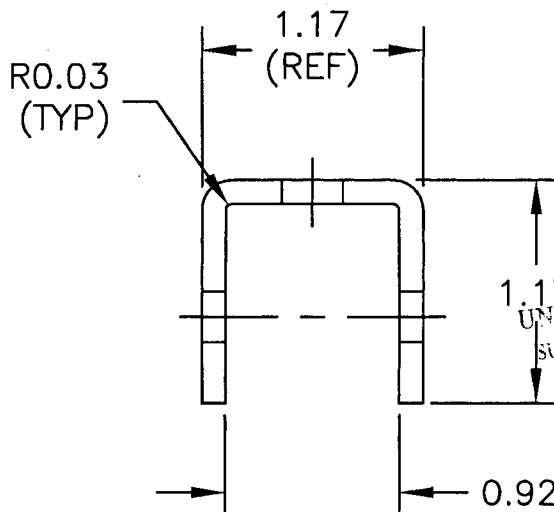
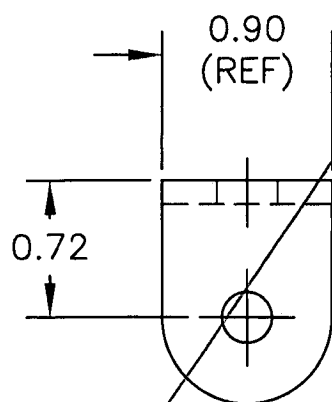


UNDER REVIEW
06.02.20
ADDITION OF HOLES
& DIMENSIONS

D3516-11F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)

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06.11.28



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D3516-11 CLEVIS BENDING DETAIL

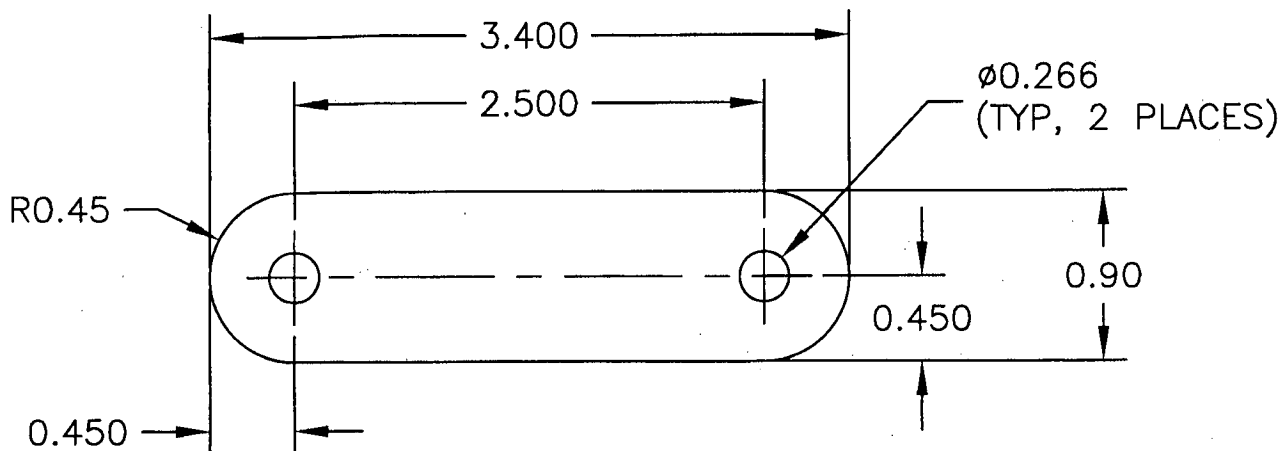
- 1) MATERIAL: MAKE FROM D3516-11F
2) ALL DIMENSIONS ARE IN INCHES
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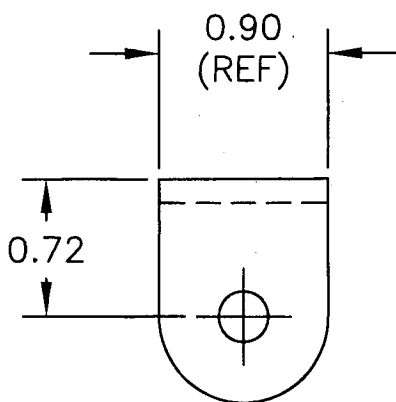


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| DATE 06.07.25 | | TITLE BASKET BASE ASSEMBLY (A119) | SCALE 1:1 |



D3516-13F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)



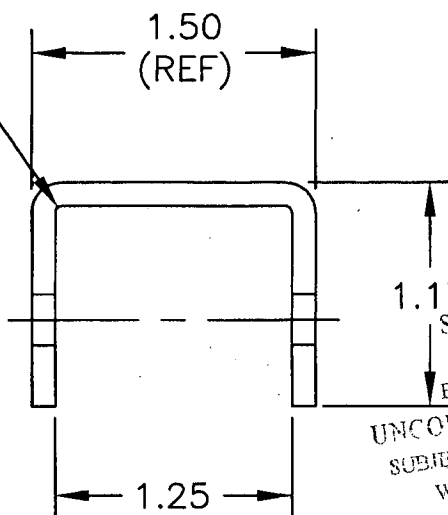
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ADDITION OF HOLES
& DIMENSION PARTS

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OK PER
REV. B



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